

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028557**Date Inspected:** 01-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Harry Scharein**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI noted and periodically observed ABF welder Erick Sparks performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1. 5-1004-Repair. The weld was excavated and magnetic particle testing performed on a previous shift. The repairs are located on the deck access hole drop-in weld for lift 13E between panel point 124 and 124.5 at the following locations;

Y=840 Depth 13, Width 18mm, Length 87mm

Y=905 Depth 12, Width 19mm, Length 63mm

Y=1100 Depth 12, Width 19mm, Length 66mm

The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and maintained throughout the welding process. The repairs were then observed to be post heated at 450°F for one hour. The repair excavations were performed in accordance with the following approval for repair documents;

Y=840 RWR201209-128

Y=905 RWR201209-129

Y=1100 RWR201209-130

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OBG 13W Deck Drop-in (DAH-13W-PP124.5-W5)

This QA randomly observed ABF/JV QC inspector John Hayes performing Ultrasonic Testing (UT) of the deck access hole drop-in weld designated as DAH-13W-PP124.5-W5. The locations Ultrasonically tested were in way of repairs performed and completed 24 hours prior. The following locations were tested;

Y=1185 No rejectable indications observed by QC.

Y=1225 No rejectable indications observed by QC.

Y=1285 No rejectable indications observed by QC.

Y=1370 No rejectable indications observed by QC.

Y=2490 One rejectable indication observed by QC.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations relevant to the work being performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
